

Work Order ID 61230

August 11, 2010 11:07:59 AM



Page 1

Item ID: D412-711-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Bubble Window

Start Date: 8/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CZ Date: 10/8/11 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-711-101	A								

100

0.00



DC

Document Control

Memo

Photocopy bluefiles and create labels
for PPP D412-711-101 Change 002

0.00

8/10/08/07

Order BG 10-8-27

110

0.00



HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Set up Machine as per folio FTA 077 and D711W program

0.00

Dr. 10/08/25

120

0.00



HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Cut Blanks to 36" by 39"

0.00

XI BB 10/08/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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August 11, 2010 11:07:59 AM

Page 3

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandThermo	HAND FINISHING THERMOFORMING	0.00							
Hand Finishing Thermoforming	Memo 1) Trim off excess flange material 2) Buff out any light scratches or 3) Etch part number and batch number	0.00							
170  QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo 1) Visually inspect for clarity, and proper formation.	0.00							
180  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo 1) Visually inspect for clarity, and proper formation.	0.00							

P107

W/O: 61230		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/05/27	185	Perm. change. Store Pick kit					10/05/27	
	185	Perm. change QC inspect kit for completeness. - 8/10/05/27 @					10/05/27	

Part No: D412-711-101 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 4

August 11, 2010 11:07:59 AM

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Required Date: 8/25/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Packaging	Identify as per dwg & Stock Location: _____ Memo 1600	0.00 0.00							
Packaging									
200 QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
Quality Control									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

August 11, 2010 11:07:59 AM

Page 1

Work Order ID: 61230



Parent Item: D412-711-101



Parent Item Name: Replacement Bubble Window

Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236		Purchased	No				sf	65.0000	16	16			

Plexiglass G .236"

Location

Loc Qty

Loc Code

therm

65

113571

17

115096

48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 61230
Description: 412 Bubble Window.	Part Number: D412-711-101
Inspection Dwg: 412-711-101/Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Wb.

Date: 10/08/26

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.50"	MIN.	1.875"	✓			
32"	REF	32.5"	✓			
31"	REF	31.0"	✓			
0.090"	MIN	0.099	✓			
0.070"	MIN	0.075	✓			
0.050"	MIN.	0.075"	✓			

Measured by: Wb.

Date: 10/08/26

Audited by: JB.

Date: 10/08/27

Preliminary Approval: _____

Date: _____

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

